

52

SPLIT

DART AEROSPACE LTD

Work Order:

19665

Description: Aft Crosstube

Part Number:

D2890

Drawing: D2890 Rev. B; D6008 Rev. A

Qty:

1 ~~14~~
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <i>Dwg. not required RF 02.11.05</i>	<i>HJ</i>	03.09.19	14
2	PG	Issue P/O: <i>2005608</i> a) Extrude as per Dwg D6008 length = 180" (Ref. D6008-180) b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11)) Seamless aluminum tube c) Minimum ultimate tensile strength = 77ksi d) Minimum tensile yield strength = 66ksi e) Material certification required	<i>U</i>	03.09.22	14
3	RG	Receive and inspect for transit damage Ensure material certification attached	<i>Q</i>	04.01.05	16
4	QC6	Inspect dimensions as per Dwg D6008 and check 180" length	<i>B</i>	04.01.13	16
5	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube	<i>ME</i>	04.01.13	16
6	LG	Bend as per Dwg D2890 and Folio FT002 Sign Page 2			
7	QC6	Inspect dimensions per Dwg D2890 Sign Page 2			
8	LG	Deburr and Polish Sign Page 2			
9	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube Sign Page 2	<i>MM</i>	05.03.07	1
10	QC5	Inspect work to Step 9 Sign Page 2	<i>Z</i>	05.03.07	1
11	ST	Identify and stock	<i>CL</i>	05/03/07	+
12	AC	Cost / part: <i>926.40</i>	<i>Syc</i>	05.05.10	1
13	DC	Close W/O <i>882.02</i> Inspect Level 21	<i>HJ</i>	05.05.10	1

Rev	Date	Change	Revised By	Approved
A	99.05.31	New Issue, ECN 200	DM	
B	00.04.11	Remove painting step	EC	
C	02.10.18	Re-format; Added spec	KJ RF	<i>JA</i>

RELEASED
02/10/30 RF

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W/O Step	A	B	C	D	E	F	G	H	I	J	K	L
6		DP 04-11-18	DP 05-2-22	DP 05-2-23								
7		Er 04/11/18	# 05-06-24	# 05-03-02								
8		DP BE 04-11-18		DP 05-3-7								
9		PD MM 04-11-22										
10												

RELEASED
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